

Thursday, May 12, 2016 1:08:58 PM

Page 1

Reference:

Run Start *NR1*
Stop *NR2*

[illegible]

Work Order ID 146216

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Page 2

Item ID: D350-822-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: PA100 PUREair System for AS350/EC130
Start Date: 5/18/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/20/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	Consignment Stock	0.00							
125 Outsourc10	Memo	0.00							
Consignment stock	Issue PO to GL account 50000-25 to LEAVE W/O OPEN UNTIL SOLD PO <u>33671</u> (Send copy of PO to Pall - James)								
	Issue W/O LINE item for Pall for amount sold on sales order S/O <u>127707</u> according to sales price see Warran for amount. (if sale price is \$23,000 - amount is \$13,400) PO can be received immediately and given to finance in order to close work order.								
130	Packaging	0.00							
130 Packaging	Memo	0.03							
Packaging	Identify and pack for shipping as per PPP D350-822-011 Location: _____								

46-01-15
DAS 27 9-89
DAS 28 9-89
JUN 09 2016

127707
DAS 27 9-89
DAS 28 9-89
JUN 09 2016

sold

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Item ID: D350-822-011**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** PA100 PUREair System for AS350/EC130**Stop *NS2*****Start Date:** 5/18/2016 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 5/20/2016 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

MLJ JUN 10 2016

MLJ JUN 10 2016

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Work Order ID: 146216

146216

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 5/18/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.02.20 NEW ISSUE DD VERF:JLM IPP
REV:B 14.06.18 AS PER IIN REV.C DD VERF:JLM IPP REV:C
15.06.03 AS PER IIN REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149D0332J		Purchased	No				Each	1,334.000		58			
NAS1149D0332.J									**				
Washer													

Location	Loc Qty	Loc Code
CA	6	
m129682	6	
FP001	11	
m133988	11	
GA	48	
m132677	48	
ST260a	600	
m134738	600	
ST264	669	
m134502	669	

QR10616

Purchased

No

Each

5.0000

1

QR10616

Vortex Tube Repair

**

Location	Loc Qty	Loc Code
FG108	1	
m129631	1	
QC INSP	4	
m133995	4	

DAS
28
9-89

DAS
27
9-89

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Work Order ID: 146216

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Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 5/18/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

QB21304 Purchased No Each 2.0000

QB21304

PUREair Panel Assembly

**

1

134946

DAS 6 27 9-89

Location

Loc Qty

Loc Code

MEZZpall

2

118409

2

Each

1.0000

**

1

134946

DAS 6 27 9-89

QB21310 Purchased No

QB21310

Transition Duct Assembly

Location

Loc Qty

Loc Code

FG108

1

m129631

1

Each

0.0000

**

1

134946

DAS 6 27 9-89

QB21308 Purchased No

QB21308

Fod Screen Assembly

LN29985-A05

I N29985-A05

Anchor Nut

Purchased No

Each

114.0000

**

15

5x11 134946x5

JUN 06 2016

Location

Loc Qty

Loc Code

ST563

114

m133062

25

m134586

29

m134726

60

Each

300.0000

**

56

DAS 6 27 9-89

LN9038-05018 Purchased No

I N9038-05018

Bolt

Location

Loc Qty

Loc Code

ST564

300

M134466

50

M134571

50

M134586

200

JUN 06 2016

DAS 6 27 9-89

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Work Order ID: 146216

146216

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 5/18/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

BS4320-A5	Purchased	No	Each	24.0000	56	**	134946	DAS 27 9-89
RS4320-A5								
Washer (NAS1149D332J)								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			MEZZpall	24				
			M129914	24				
MS20426AD3-3	Purchased	No	Each	2,579.000	40	**		DAS 27 9-89
MS20426AD3-3								
RIVET								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			GA	828				
			M131624	828				
			ST312	1751				
			M131624	1751				
650.0401	Purchased	No	Each	19.0000	1	**		DAS 27 9-89
650 0401								
PUREair Fairing Assembly								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FG109	19				
			132155	19				
D4925-041	Manufactured	No	Each	0.0000	1	**		DAS 27 9-89
D4925-041								
Mounting Plate Assembly								
D4931-1	Manufactured	No	Each	16.0000	1	**		DAS 27 9-89
D4931-1								
Engine Fitting (for acft models B2 & previous)								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			st138	16				
			144653	16				

JUN 06 2016

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Work Order ID: 146216

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Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 5/18/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

D4931-3 Manufactured No

Each 7.0000

1

D4931-3

**

Engine Fitting (for B3 models)

Location

Loc Qty

Loc Code

st138

7

120907

7

Each

10.0000

1

D4931-5

Manufactured No

D4931-5

**

Engine Fitting (for B3e models)

Location

Loc Qty

Loc Code

st138

10

120908

10

Each

15.0000

6

D4935-1

Manufactured No

D4935-1

**

Mounting Bracket

Location

Loc Qty

Loc Code

ST139

15

144648

15

Each

27.0000

1

D4943-1

Manufactured No

D4943-1

**

Flex Hose

Location

Loc Qty

Loc Code

ST220a

11

119754

8

119755

3

st220b

16

119751

8

119752

8

D4961-041

Manufactured No

D4961-041

**

Tube Assembly

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Page 4

DAS
6
27
9-89

DAS
6
27
9-89

DAS
6
27
9-89

DAS
6
27
9-89

DAS
6
27
9-89

DAS
6
27
9-89

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Work Order ID: 146216

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Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 5/18/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

9752018044

Purchased

No

Each

17.0000

1

9752018044

Gasket (for B3 models)

DAS
6 27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST564

1

m129550

1

ST589

16

m134540

8

m134710

8

9945000120

Purchased

No

Each

17.0000

1

9945000120

Gasket (for B3e models)

DAS
6 27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST564

1

m129550

1

ST589

16

m134540

8

m134710

8

23350CA050

Purchased

No

Each

53.0000

2

23350CA050

WASHER

DAS
6 27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST568

53

m129609

53

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Work Order ID: 146216

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Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 5/18/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

AN821-12J Purchased No

Each 14.0000

2

AN821-12J

Elbow (or AN821-12K or 12S)

**

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

CCK004

12

m134544

12

ST324

2

m132479

2

Each

7.0000

1

**

DAS 6 27
9-89 9-89

AN929-12J

Purchased No

AN929-12J

Cap

**

Location

Loc Qty

Loc Code

ST322

7

m129764

7

Each

16.0000

2

**

DAS 6 27
9-89 9-89

EN3686-050016

Purchased No

FN3686-050016

Screw

**

Location

Loc Qty

Loc Code

ST559

16

m132539

1

m134586

15

Each

156.0000

32

**

DAS 6 27
9-89 9-89

LN9038-05012

Purchased No

I N9038-05012

Bolt

**

Location

Loc Qty

Loc Code

ST564

156

m134466

56

m134571

100

32

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Work Order ID: 146216

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Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 5/18/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

LN9038-05040

Purchased

No

Each

7.0000

1

I N9038-05040

**

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST564

7

m132423

3

m134466

4

LN9348-05

Purchased

No

Each

140.0000

26

I N9348-05

**

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST564

140

m134466

140

MS20470AD3-4

Purchased

No

Each

1,548.000

18

MS20470AD3-4

**

Rivet,Universal Head

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

556

111477

556

ST310

992

111477

992

MS21919WCH12

Purchased

No

Each

11.0000

1

MS21919WCH12

**

Clamp

DAS
28
9-89

Location

Loc Qty

Loc Code

ST291

11

m130358

1

m134527

10

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Work Order ID: 146216

146216

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 5/18/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

MS9592-138

Purchased

No

Each

18.0000

1

MS9592-138

Bracket

DAS
28
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST267

18

m132479

18

Each

23.0000

1

NAS43DD3-64

Purchased

No

NAS43DD3-64

Spacer

DAS
28
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

8

m132461

8

ST550

15

m134544

15

JUN 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Work Order ID 146216

146216

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Item ID: D350-822-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: PA100 PUREair System for AS350/EC130

Start Date: 5/18/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/20/2016 Req'd Qty: 1.00 ***1*** Customer:

Reference: Run Start ***NR1***
 Approvals: Process Plan: SEN Date: 5/18/16 Tooling: Date: Stop ***NR2***
 QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
100		0.02							
DC	Memo								
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-822-011 CHG002								
110	Pick Kit	0.00							
110		0.02							
Packaging	Memo								
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120		0.03							
QC	Memo								
Quality Control									

JUN 06 2016

MAY 16 2016

ML

JUN 06 2016

JUN 06 2016

MAY 16 2016

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND IIN-D350-822 REV. C/D
REF. TCCA STC: SH14-14
REF. ANAC STC: 2014S07-11

1.0 PURPOSE

THE PURPOSE OF THIS DSI IS TO PROVIDE AN UPGRADE KIT SO THAT CUSTOMERS WHO HAVE RECEIVED D350-822-011 @ CHG 001 (REF IIN-D350-822 REV. C) CAN UPGRADE THEIR KIT TO D350-822-011 @ CHG 002 (REF IIN-D350-822 REV. D) AND INSTALL THE KIT PER IIN-D350-822 REV. D.

2.0 CHANGE

THE DSI 9723-011 UPGRADE KIT IS DETAILED AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9723-011	PA100 PUREAIR SYSTEM UPGRADE KIT
1	650.0401	PUREAIR FAIRING ASSY *
1	AN821-12J	ELBOW
58	BS4320-A5	WASHER (OR NAS1149D0332J)
1	D4925-041	MOUNTING PLATE ASSY *
1	D4961-043	TUBE ASSEMBLY
2	D5179-1	DOUBLER
2	D5179-3	DOUBLER
2	D5194-1	DOUBLER
3	D5208-041	BLANKING PLATE ASSY
2	EN3686-050016	SCREW
15	LN29985-A05	ANCHOR NUT
32	LN9038-05012	BOLT
56	LN9038-05018	BOLT
1	LN9038-05040	BOLT
26	LN9348-05	NUT
40	MS20426AD3-3	RIVET
1	MS9592-138	BRACKET
1	NAS43DD3-64	SPACER

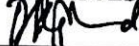
* UPGRADE TO METRIC HARDWARE

3.0 WEIGHT AND BALANCE

This DSI has a negligible effect on Weight and Balance.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.05.29
CERT. NO.: SH14-14
ISSUE NO.: 1

A	NEW ISSUE	AK	15.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9723	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.		PA100 UPGRADE KIT	NTS
DATE	15.05.29	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		D350-822-011	PA100 PUREAIR SYSTEM
	X	D350-822-013	PA100 PUREAIR PROVISIONS
1		QB05008	PUREAIR SYSTEM
1**		QR10616	TUBE REPAIR KIT
1**		QB21304	PUREAIR PANEL ASSY
1**		QB21310	TRANSITION DUCT ASSY
1**		QB21308	FOD SCREEN ASSY
15**		LN29985-A05	ANCHOR NUT
56**		LN9038-05018	BOLT
56**		BS4320-A5	WASHER
40**		MS20426AD3-3	RIVET
1	1	650.0401	PUREAIR FAIRING ASSY
1	1	D4925-041	MOUNTING PLATE ASSY
1*	1*	D4931-1	ENGINE FITTING
1*	1*	D4931-3	ENGINE FITTING
1*	1*	D4931-5	ENGINE FITTING
6	6	D4935-1	MOUNTING BRACKET
1	1	D4943-1	FLEX HOSE
1	1	D4961-041	TUBE ASSEMBLY
1	1	D4961-043	TUBE ASSEMBLY
2	2	D5079-1	PLACARD
1	1	D5090-041	DUCT ASSEMBLY
2	2	D5105-1	HANDLE
1	1	D5110-1	SWIVEL NUT FITTING
2	2	D5179-1	DOUBLER
2	2	D5179-3	DOUBLER
2	2	D5194-1	DOUBLER
3	3	D5208-041	BLANKING PLATE ASSY
1*	1*	9752100180	GASKET
1*	1*	9945000120	GASKET
2	2	23350CA050	LOCKING TAB
2	2	AN821-12J	ELBOW (OR AN821-12K OR AN821-12S)
1	1	AN929-12J	CAP
58	58	BS4320-A5	WASHER (OR NAS1149D0332J)
2	2	EN3686-050016	SCREW
32	32	LN9038-05012	BOLT
1	1	LN9038-05040	BOLT
26	26	LN9348-05	NUT
18	18	MS20470AD3-4	RIVET
1	1	MS21919WHG12	CLAMP
1	1	MS9592-138	BRACKET
1	1	NAS43DD3-64	SPACER

* USE APPROPRIATE FITTING/GASKET BASED ON ENGINE INSTALLATION

** PART OF QB05008 ABOVE